

5/25

Split A

DART AEROSPACE LTD	Work Order:	23257
Description: Plug	Part Number:	D2594-1
Dwg: D2594 Rev. B1	Qty:	300 32
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	AP	05/05/10	300
2	MC	Make as per Dwg D2594-1 and Folio FA262. Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625) Batch M116807	ML	05/10/17	300
3	MC	Break all sharp edge	DL	05/10/25	300
4	QC3	Inspect dimensions	ML	05/10/17	300
4.5	QC3	Second check	ML	05/10/25	300
5	FP	Acid etch and alodi	ML	05-11-01	32
6	FP	Powder Coat Gloss (only larger dia. s	SI 005 4.3 127/24428	05-11-01	32
7	QC3	Inspect Powder Co	ML	05/11/01	32
8	FP	Identify and Stock	ML	05/11/01	32
9	AC	Cost / part	ML	05-11-02	32
10	DC	Close W/O Inspect Level 21	ML	05-11-02	32

Rev	Date	Change	Revised By	Approved
A	98.11.27	New Issue	DM	
B	00.11.01	Removed P/O for Powder Coat – in house process	EC	
C	01.07.17	Reformat step 2	SM	
D	02.08.22	Make in Cobra	KJ	

RELEASED
02/08/22 RF

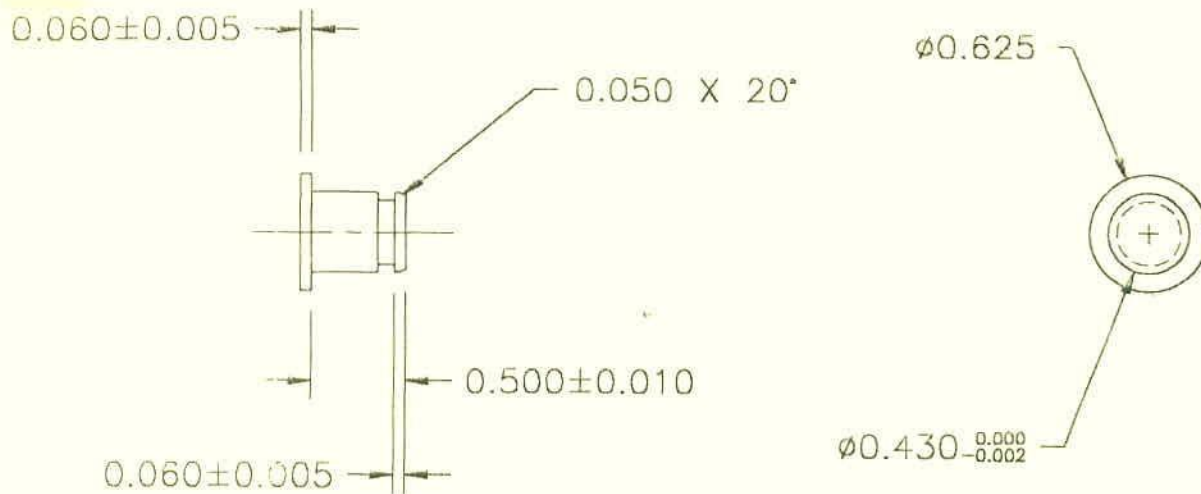
DART



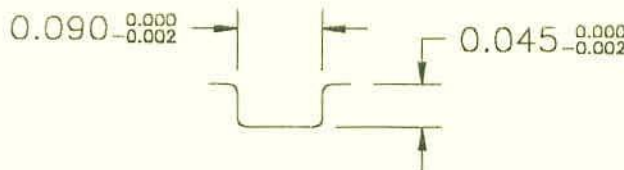
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2594	REV. B SHEET 1 OF 1
DATE 96:09:16		TITLE PLUG	SCALE 1:1
B	97:03:15	ADD GROOVE AND O-RING	
B1	# 2F 02.08.26	ADD POWDER COAT, QSE 018, & QQ-A SPECS.	

D2594-1 PLUG:

RELEASED
97/03/27 DS



GROOVE DETAIL (SCALE 5:1)



UNCOIL
SUBJECT TO
WITH BEST NO.
WORK ORDER
NO. 43257

TOLEANCES ARE PER DMT QSE 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP CORNERS 0.010 MAX
MATERIAL: 5052-H32 OR 6061-T6 OR 1100-O
FINISH: ACID ETCH, ALODINE
POWDER COAT WHITE (REF. 43.5.1) PER QSE COS 4.3

PER QQ-A-225 / 7 (5052)
OR QQ-A-225 / 8 (6061)
OR QQ-A-225 / 1 (1100)
OR QQ-A-200 / 8 (6061)

B1

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH
(PARKER 2-011)

D2594 PLUG ASSEMBLY INCLUDES: (1) D2594-1 PLUG
(1) D2594-3 O-RING

